

Date: Thursday, 1/25/2007 10:21:12 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : NUT PLATE ASSEMBLY
 Job Number : 30449
 Estimate Number : 11053
 P.O. Number : N/A Part Number : D2873043
 This Issue : 1/25/2007 S.O. No. : N/A Drawing Number : D2873 REVA
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : A
 Previous Run : 29286 Material : N/A
 Due Date : 2/22/2007 Qty: 40 Um: Each
 Written By :
 Checked & Approved By : 07.01.25
 Comment : Est A05.09.13 New issue KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0375X01000 6061T6 BAR



Comment: Qty.: 0.3237 f(s)/Unit Total : 12.9486 f(s)

6061T6 BAR

Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-225/8)

(M6061T6B0.375x01.000)

Identify for D2873-3

M103434 x 9 pcs

Batch: M102651 x 31 pcs

J.L 07/03/03

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blanks: 1.000" x 0.375" x 3.700" long

J.L 07/03/03

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA and Dwg D2873

Identify as D2873-3

Dwg Rev A Folio Rev AA

J.L 07/03/04

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 07/03/04

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mk 07/03/04

40

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2- C'sink as per Dwg D2873

FF 07-03-05

40

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

mk 07/03/07

(40)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JD 7-3-7

(40)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION

FF 07-03-08

40

10.0

MS20426AD46

Rivet



Comment: Qty.: 6.0000 Each(s)/Unit Total: 240.0000 Each(s)

Rivet

Pick;

Qty

Part Number

Description

Batch

6

MS20426AD4-6

Rivet

M100151

FF 07-03-08

40

11.0

MS21075L5

Nut Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total: 120.0000 Each(s)

Nut Plate

Pick;

Qty

Part Number

Description

Batch

3

MS21075L5

Nut Plate

M118136

FF 07-03-08

40

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/09

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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Process Sheet

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Part Number: D2873043

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D2873

2-Identify as D2873-043

FF 07-03-08

40

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/08 (40)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/03/08 (40) C

15.0

QC21

FINAL INSPECTION/W/O RELEASE



(40)

Comment: FINAL INSPECTION/W/O RELEASE

07/03/09

Job Completion



u 07-03-09

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

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|--|--|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 30449 |
| Description: Radius Block | | Part Number: | D2873-3 |
| Inspection Dwg: D2873 Rev: A | | Page 1 of 1 | |

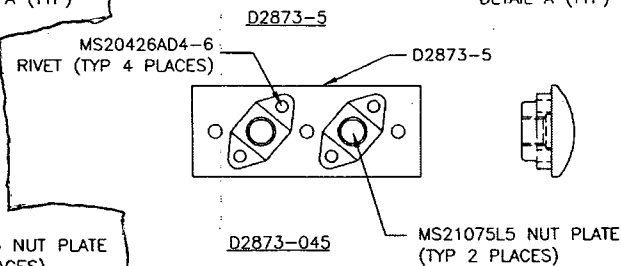
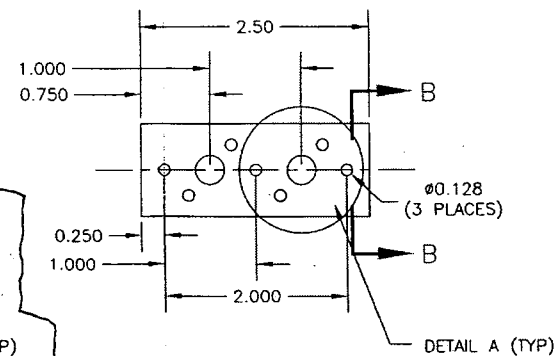
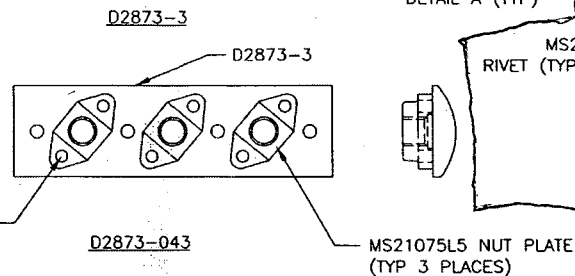
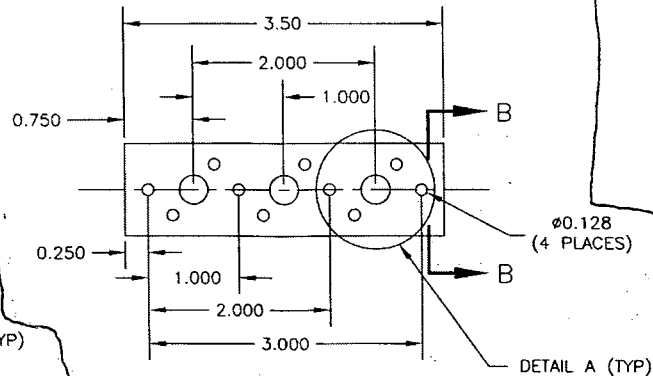
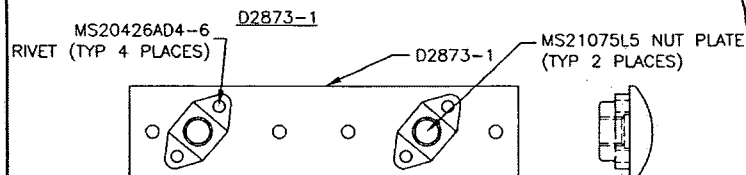
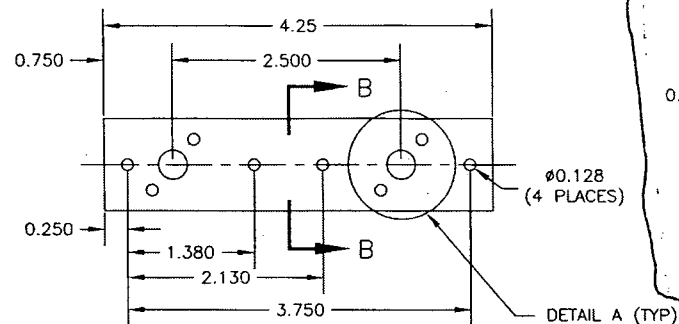
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------------------|------------------|--------|--------|----------------------|----------|
| 3.50 | +/-0.030 | 3.501 | ✓ | | | |
| 2.000 | +/-0.010 | 2.000 | ✓ | | | |
| 0.750 | +/-0.010 | .750 | ✓ | | | |
| 1.000 | +/-0.010 | 1.000 | ✓ | | | |
| 0.250 | +/-0.010 | .250 | ✓ | | | |
| 1.000 | +/-0.010 | 1.000 | ✓ | | | |
| 2.000 | +/-0.010 | 2.000 | ✓ | | | |
| 3.000 | +/-0.010 | 2.999 | ✓ | | | |
| Ø0.128 | +0.005/-0.001 | .130 | ✓ | | | |
| 0.359 | +/-0.010 | .359 | ✓ | | | |
| Ø0.316 | +0.006/-0.001 | .319 | ✓ | | | |
| 1.000 | +/-0.010 | 1.002 | ✓ | | | |
| 0.250 | +/-0.010 | .249 | ✓ | | | |
| 0.061 | +/-0.010 | .062 | ✓ | | | |
| Ø0.230 x 0.125 | +0.005/-0.001 x 0.010 | .234 x .128 | ✓ | | | |
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|---------------------|----------|--------------------|----------|----------------------------|-----|
| Measured by: | J.L | Audited by: | ml | Prototype Approval: | N/A |
| Date: | 07/03/03 | Date: | 07/03/03 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|------------------------------|------------|--------------------|
| A | 06.08.30 | New Issue P/O D2873-043 | KJ/JLM | <i>[Signature]</i> |



D2873-041

D2873-1/-3/-5 RADIUS BLOCK

- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X0.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X0.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 x 100'

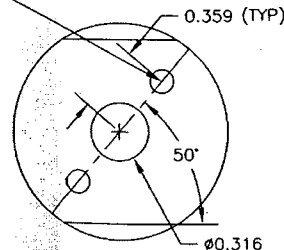
D2873-041/-043/-045 NUT PLATE ASSEMBLY

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

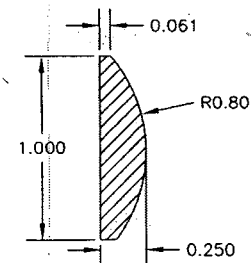
D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

| -041 | -043 | -045 | PART NUMBER | DESCRIPTION |
|------|------|------|--------------|--------------------|
| X | | | D2873-041 | NUT PLATE ASSEMBLY |
| | X | | D2873-043 | NUT PLATE ASSEMBLY |
| | | X | D2873-045 | NUT PLATE ASSEMBLY |
| 1 | | | D2873-1 | RADIUS BLOCK |
| | 1 | | D2873-3 | RADIUS BLOCK |
| | | 1 | D2873-5 | RADIUS BLOCK |
| 4 | 6 | 4 | MS20426AD4-6 | RIVET |
| 2 | 3 | 2 | MS21075L5 | NUT PLATE |

(-041 4 PLACES)
(-043 6 PLACES)
(-045 4 PLACES)



DETAIL A (SCALE 2:5)



SECTION B-B (SCALE 2:5)

RELEASED 05.07.26

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
304419

| | | |
|---------------|--------------------|---|
| A | 05.07.26 | NEW ISSUE |
| DESIGN PH | DRAWN BY PH | DART DART AEROSPACE LTD WARRICKS, ONTARIO, CANADA |
| CHECKED DS | APPROVED DS | DRAWING NO. D2873 |
| DATE 05.07.26 | TITLE RADIUS BLOCK | REV. A SHEET 1 OF 1 SCALE 4:5 |